```
        SRF – 650MHZ
      CAVITY, BETA = 0.9
     SINGLE CELL ASSEMBLY
 SERIAL NUMBER: B9AS-AES-002
RF#94364
INSPECTOR: O. LIRA
```

| ⌖ | MM | LOC1 - DATUM_C | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| Y | 0.000 | 0.000 | 0.500 | 0.500 | 0.000 | 0.000 | |
| FL | 0.000 | 0.007 | 0.400 | 0.000 | 0.007 | 0.000 | |

| ⌖ | MM | LOC2 - LEFT_FLANGE_PLN | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| Y | 567.500 | 564.786 | 0.500 | 0.500 | -2.714 | -2.214 | |
| FL | 0.000 | 0.030 | 0.400 | 0.000 | 0.030 | 0.000 | |

| ⌖ | MM | LOC3 - RIGHT_FLANGE_SEAL_SURF | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| Y | 1.000 | 0.992 | 0.500 | 0.500 | -0.008 | 0.000 | |
| FL | 0.000 | 0.004 | 0.250 | 0.000 | 0.004 | 0.000 | |

| FCFPERP1 | MM | ⊥ 0.4 B | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| DATUM_C | 0.000 | 0.020 | 0.400 | 0.000 | 0.020 | 0.000 | |

| FCFPERP2 | MM | ⊥ 0.4 A | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| LEFT_FLANGE_... | 0.000 | 0.101 | 0.400 | 0.000 | 0.101 | 0.000 | |

| FCFPARL1 | MM | // 0.5 C | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| LEFT_FLANGE_... | 0.000 | 0.181 | 0.500 | 0.000 | 0.181 | 0.000 | |

| ⌖ | MM | LOC4 - DATUM_C | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| AX | | I | | J | | K | |
| V | | 0.000 | | -1.000 | | 0.000 | |

| ⌖ | MM | LOC5 - LEFT_FLANGE_PLN | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| AX | | I | | J | | K | |
| V | | -0.001 | | 1.000 | | 0.000 | |

| ⌖ | MM | LOC6 - RIGHT_FLANGE_SEAL_SURF | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| AX | | I | | J | | K | |
| V | | 0.000 | | -1.000 | | 0.000 | |

| ⌖ | MM | LOC7 - LEFT_FLANGE_SEAL_SURF | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| AX | | I | | J | | K | |
| V | | 0.000 | | 1.000 | | 0.000 | |

| ⌖ | MM | LOC8 - RIGHT_FLANGE_BEAM_TUBE_PLN | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| AX | | I | | J | | K |
| V | | 0.000 | | -1.000 | | 0.000 |

| ⌖ | MM | LOC9 - LEFT_FLANGE_BEAM_TUBE_PLN | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| AX | | I | | J | | K |
| V | | 0.000 | | 1.000 | | 0.000 |

| ↔ | MM | DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| M | 1.000 | 1.037 | 0.200 | 0.200 | 0.037 | 0.000 | |

| ▱ | MM | FLAT1 - LEFT_FLANGE_SEAL_SURF | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| M | 0.000 | 0.014 | 0.250 | 0.000 | 0.014 | 0.000 | |

| ⌖ | MM | LOC10 - DATUM_B | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| D | 100.000 | 100.242 | 0.200 | 0.200 | 0.242 | 0.042 | |
| RN | 0.000 | 0.247 | 0.050 | 0.000 | 0.247 | 0.197 | |

| ⌖ | MM | LOC11 - DATUM_A_CYL1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| D | 100.000 | 100.320 | 0.200 | 0.200 | 0.320 | 0.120 | |
| RN | 0.000 | 0.330 | 0.050 | 0.000 | 0.330 | 0.280 | |

| ⌖ | MM | LOC12 - DAT_B_DAT_A_CYL1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| D | 100.000 | 100.281 | 0.050 | 0.050 | 0.281 | 0.231 | |
| RN | 0.000 | 0.390 | 0.050 | 0.000 | 0.390 | 0.340 | |

| ⌖ | MM | LOC13 - DATUM_B_END1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
| X | 0.000 | -0.019 | | | -0.019 | | |
| Y | 0.000 | 0.000 | | | 0.000 | | |
| Z | 0.000 | -0.023 | | | -0.023 | | |
| TP | RFS | 0.059 | 0.500 | | 0.059 | 0.000 | 0.000 |

| ⌖ | MM | LOC14 - DATUM_B_END2 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | 0.025 | | | 0.025 | |
| Y | 170.000 | 170.000 | | | 0.000 | |
| Z | 0.000 | 0.018 | | | 0.018 | |
| TP | RFS | 0.061 | 0.500 | | 0.061 | 0.000 |

| ⌖ | MM | LOC17 - DATUM_A_END1 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | -0.005 | | | -0.005 | |
| Y | 567.500 | 567.500 | | | 0.000 | |
| Z | 0.000 | -0.041 | | | -0.041 | |
| TP | RFS | 0.082 | 0.500 | | 0.082 | 0.000 |

| ⊕ | MM | | LOC18 - DATUM_A_END2 | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| X | 0.000 | 0.000 | | | 0.000 | | |
| Y | 397.500 | 397.500 | | | 0.000 | | |
| Z | 0.000 | 0.046 | | | 0.046 | | |
| TP | RFS | 0.093 | 0.500 | | 0.093 | 0.000 | |

| ⌖ | MM | | LOC19 - FLANGE_RIGHT_OD | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| X | 0.000 | 0.000 | 0.050 | 0.050 | 0.000 | 0.000 | |
| Z | 0.000 | -0.019 | 0.050 | 0.050 | -0.019 | 0.000 | |
| D | 170.000 | 169.954 | 0.200 | 0.200 | -0.046 | 0.000 | |
| RN | 0.000 | 0.029 | 0.100 | 0.000 | 0.029 | 0.000 | |

| ⌖ | MM | | LOC20 - FLANGE_LEFT_OD | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| X | 0.000 | 0.044 | 0.050 | 0.050 | 0.044 | 0.000 | |
| Z | 0.000 | -0.040 | 0.050 | 0.050 | -0.040 | 0.000 | |
| D | 170.000 | 169.909 | 0.200 | 0.200 | -0.091 | 0.000 | |
| RN | 0.000 | 0.020 | 0.100 | 0.000 | 0.020 | 0.000 | |

| ⊕ | MM | | LOC18 - DATUM_A_END2 | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |

| | MM | LOC21 - MID_WELD_CIR1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | |
| X | 0.000 | -0.029 | 0.500 | 0.500 | -0.029 | 0.000 | |
| Y | 283.750 | 283.554 | 0.500 | 0.500 | -0.196 | 0.000 | |
| Z | 0.000 | -0.013 | 0.500 | 0.500 | -0.013 | 0.000 | |
| D | 404.550 | 404.701 | 0.050 | 0.000 | 0.151 | 0.101 | |
| RN | 0.000 | 0.478 | 0.200 | 0.000 | 0.478 | 0.278 | |
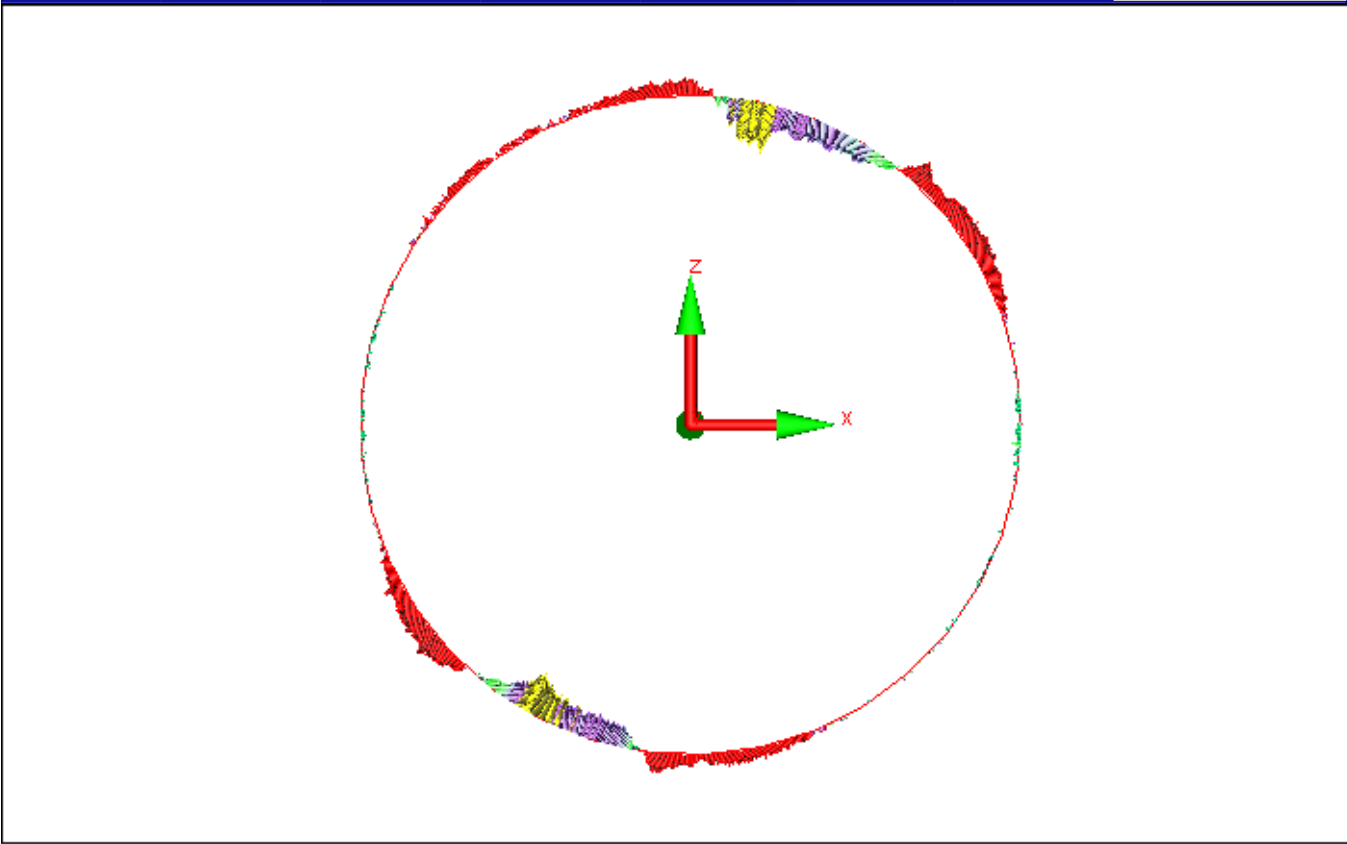
PROFILE OF TWO HALF CELLS CENTER WELD CIRCLE

   FOR THE FOLLOWING BOLT CIRCLE POSITIONS
TWO SECONDARY DATUM'S WERE CREATED AS FOLLOW:

1) RIGHT FLANGE SEALING SURFACE DATUM= RF

2) LEFT FLANGE SEALING SURFACE DATUM= LF

3) RIGHT FLANGE OUTSIDE DIAMETER DATUM= RO

4) LEFT FLANGE OUTSIDE DIAMETER DATUM= LO

   (SEE DRAWING 481600 FLANGE, HEX-SEAL)

********************************************************

| FCFLOC1 Size | MM | 18X⌀8.5 0.13/0.13 | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
| FLANGE_RIG... 8.500 | 8.495 | 0.130 | 0.130 | -0.005 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.500 | 0.130 | 0.130 | 0.000 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.488 | 0.130 | 0.130 | -0.012 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.500 | 0.130 | 0.130 | 0.000 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.497 | 0.130 | 0.130 | -0.003 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.493 | 0.130 | 0.130 | -0.007 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.495 | 0.130 | 0.130 | -0.005 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.513 | 0.130 | 0.130 | 0.013 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.502 | 0.130 | 0.130 | 0.002 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.497 | 0.130 | 0.130 | -0.003 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.522 | 0.130 | 0.130 | 0.022 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.497 | 0.130 | 0.130 | -0.003 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.518 | 0.130 | 0.130 | 0.018 | 0.000 | 0.000 | |
| FLANGE_RIG... 8.500 | 8.493 | 0.130 | 0.130 | -0.007 | 0.000 | 0.000 | |

| FCFLOC1 Position | MM | ⌖ ⌀0.2 Ⓜ RF RO | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
| FLANGE_RIGH... 0.000 | 0.069 | 0.200 | | 0.069 | 0.000 | 0.125 | |
| FLANGE_RIGH... 0.000 | 0.048 | 0.200 | | 0.048 | 0.000 | 0.126 | |
| FLANGE_RIGH... 0.000 | 0.032 | 0.200 | | 0.032 | 0.000 | 0.130 | |
| FLANGE_RIGH... 0.000 | 0.028 | 0.200 | | 0.028 | 0.000 | 0.118 | |
| FLANGE_RIGH... 0.000 | 0.018 | 0.200 | | 0.018 | 0.000 | 0.130 | |
| FLANGE_RIGH... 0.000 | 0.042 | 0.200 | | 0.042 | 0.000 | 0.127 | |

| Feature | DEV1 | | DEV2 | | Graph |
|---|---|---|---|---|---|
| FLANGE_RIGHT_CIR7 | 0.099 | | 0.126 | | |
| FLANGE_RIGHT_CIR8 | 0.131 | | 0.123 | | |
| FLANGE_RIGHT_CIR9 | 0.123 | | 0.125 | | |
| FLANGE_RIGHT_CIR10 | 0.137 | | 0.143 | | |
| FLANGE_RIGHT_CIR11 | 0.149 | | 0.132 | | |
| FLANGE_RIGHT_CIR12 | 0.181 | | 0.127 | | |
| FLANGE_RIGHT_CIR13 | 0.150 | | 0.152 | | |
| FLANGE_RIGHT_CIR14 | 0.155 | | 0.127 | | |
| FLANGE_RIGHT_CIR15 | 0.136 | | 0.126 | | |
| FLANGE_RIGHT_CIR16 | 0.156 | | 0.126 | | |
| FLANGE_RIGHT_CIR17 | 0.139 | | 0.148 | | |
| FLANGE_RIGHT_CIR18 | 0.130 | | 0.123 | | |

**FCFLOC1 Datum Shift**

| Segment | Shift X | Shift Y | Shift Z | Rotation X | Rotation Y | Rotation Z |
|---|---|---|---|---|---|---|

**FCFLOC1 Summary  FIT TO DATUMS=ON,  DEV PERPEN CENTERLINE=ON**

| Feature | AX | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| Set | PR | 0.000 | 0.047 | 0.047 |
| | PA | 129.136 | 234.827 | 105.691 |
| FLANGE_RIGHT_TOP_CIR1 | PR | 75.800 | 75.766 | -0.034 |
| | PA | 90.000 | 90.000 | 0.000 |
| FLANGE_RIGHT_CIR2 | PR | 75.800 | 75.776 | -0.024 |
| | PA | 110.000 | 110.001 | 0.001 |
| FLANGE_RIGHT_CIR3 | PR | 75.800 | 75.786 | -0.014 |
| | PA | 130.000 | 130.006 | 0.006 |
| FLANGE_RIGHT_CIR4 | PR | 75.800 | 75.792 | -0.008 |
| | PA | 150.000 | 150.008 | 0.008 |
| FLANGE_RIGHT_CIR5 | PR | 75.800 | 75.804 | 0.004 |
| | PA | 170.000 | 170.006 | 0.006 |
| FLANGE_RIGHT_CIR6 | PR | 75.800 | 75.821 | 0.021 |
| | PA | 190.000 | 190.000 | 0.000 |
| FLANGE_RIGHT_CIR7 | PR | 75.800 | 75.849 | 0.049 |
| | PA | 210.000 | 209.998 | -0.002 |
| FLANGE_RIGHT_CIR8 | PR | 75.800 | 75.859 | 0.059 |
| | PA | 230.000 | 229.979 | -0.021 |
| FLANGE_RIGHT_CIR9 | PR | 75.800 | 75.841 | 0.041 |

| Feature | | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| | PA | 250.000 | 249.966 | -0.034 |
| FLANGE_RIGHT_CIR10 | PR | 75.800 | 75.831 | 0.031 |
| | PA | 270.000 | 269.954 | -0.046 |
| FLANGE_RIGHT_CIR11 | PR | 75.800 | 75.799 | -0.001 |
| | PA | 290.000 | 289.944 | -0.056 |
| FLANGE_RIGHT_CIR12 | PR | 75.800 | 75.792 | -0.008 |
| | PA | 310.000 | 309.932 | -0.068 |
| FLANGE_RIGHT_CIR13 | PR | 75.800 | 75.791 | -0.009 |
| | PA | 330.000 | 329.944 | -0.056 |
| FLANGE_RIGHT_CIR14 | PR | 75.800 | 75.792 | -0.008 |
| | PA | 350.000 | 349.942 | -0.058 |
| FLANGE_RIGHT_CIR15 | PR | 75.800 | 75.774 | -0.026 |
| | PA | 10.000 | 9.953 | -0.047 |
| FLANGE_RIGHT_CIR16 | PR | 75.800 | 75.753 | -0.047 |
| | PA | 30.000 | 29.953 | -0.047 |
| FLANGE_RIGHT_CIR17 | PR | 75.800 | 75.742 | -0.058 |
| | PA | 50.000 | 49.971 | -0.029 |
| FLANGE_RIGHT_CIR18 | PR | 75.800 | 75.737 | -0.063 |
| | PA | 70.000 | 69.986 | -0.014 |

| FCFLOC2 Size | MM | 18X⌀8.5  0.13/0.13 |
|---|---|---|

| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS | |
|---|---|---|---|---|---|---|---|---|
| FLANGE_LEF... | 8.500 | 8.557 | 0.130 | 0.130 | 0.057 | 0.000 | 0.187 | |
| FLANGE_LEF... | 8.500 | 8.536 | 0.130 | 0.130 | 0.036 | 0.000 | 0.166 | |
| FLANGE_LEF... | 8.500 | 8.558 | 0.130 | 0.130 | 0.058 | 0.000 | 0.188 | |
| FLANGE_LEF... | 8.500 | 8.544 | 0.130 | 0.130 | 0.044 | 0.000 | 0.174 | |
| FLANGE_LEF... | 8.500 | 8.539 | 0.130 | 0.130 | 0.039 | 0.000 | 0.169 | |
| FLANGE_LEF... | 8.500 | 8.549 | 0.130 | 0.130 | 0.049 | 0.000 | 0.179 | |
| FLANGE_LEF... | 8.500 | 8.583 | 0.130 | 0.130 | 0.083 | 0.000 | 0.213 | |
| FLANGE_LEF... | 8.500 | 8.550 | 0.130 | 0.130 | 0.050 | 0.000 | 0.180 | |
| FLANGE_LEF... | 8.500 | 8.543 | 0.130 | 0.130 | 0.043 | 0.000 | 0.173 | |
| FLANGE_LEF... | 8.500 | 8.542 | 0.130 | 0.130 | 0.042 | 0.000 | 0.172 | |
| FLANGE_LEF... | 8.500 | 8.533 | 0.130 | 0.130 | 0.033 | 0.000 | 0.163 | |
| FLANGE_LEF... | 8.500 | 8.534 | 0.130 | 0.130 | 0.034 | 0.000 | 0.164 | |
| FLANGE_LEF... | 8.500 | 8.546 | 0.130 | 0.130 | 0.046 | 0.000 | 0.176 | |
| FLANGE_LEF... | 8.500 | 8.544 | 0.130 | 0.130 | 0.044 | 0.000 | 0.174 | |
| FLANGE_LEF... | 8.500 | 8.546 | 0.130 | 0.130 | 0.046 | 0.000 | 0.176 | |
| FLANGE_LEF... | 8.500 | 8.535 | 0.130 | 0.130 | 0.035 | 0.000 | 0.165 | |
| FLANGE_LEF... | 8.500 | 8.555 | 0.130 | 0.130 | 0.055 | 0.000 | 0.185 | |
| FLANGE_LEF... | 8.500 | 8.554 | 0.130 | 0.130 | 0.054 | 0.000 | 0.184 | |

| FCFLOC2 Position | MM | ⊕ | ⌀0.2 Ⓜ | LF | LO |
|---|---|---|---|---|---|

| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS | |
|---|---|---|---|---|---|---|---|---|
| FLANGE_LEFT_CIR1 | 0.000 | 0.030 | 0.200 | | 0.030 | 0.000 | 0.187 | |
| FLANGE_LEFT_CIR2 | 0.000 | 0.051 | 0.200 | | 0.051 | 0.000 | 0.166 | |
| FLANGE_LEFT_CIR3 | 0.000 | 0.033 | 0.200 | | 0.033 | 0.000 | 0.188 | |

| Feature | Value 1 | Value 2 | |
|---|---|---|---|
| FLANGE_LEFT_CIR4 | 0.032 | 0.174 | |
| FLANGE_LEFT_CIR5 | 0.043 | 0.169 | |
| FLANGE_LEFT_CIR6 | 0.016 | 0.179 | |
| FLANGE_LEFT_CIR7 | 0.032 | 0.213 | |
| FLANGE_LEFT_CIR8 | 0.019 | 0.180 | |
| FLANGE_LEFT_CIR9 | 0.030 | 0.173 | |
| FLANGE_LEFT_CIR10 | 0.039 | 0.172 | |
| FLANGE_LEFT_CIR11 | 0.067 | 0.163 | |
| FLANGE_LEFT_CIR12 | 0.029 | 0.164 | |
| FLANGE_LEFT_CIR13 | 0.018 | 0.176 | |
| FLANGE_LEFT_CIR14 | 0.014 | 0.174 | |
| FLANGE_LEFT_CIR15 | 0.009 | 0.176 | |
| FLANGE_LEFT_CIR16 | 0.038 | 0.165 | |
| FLANGE_LEFT_CIR17 | 0.025 | 0.185 | |
| FLANGE_LEFT_CIR18 | 0.062 | 0.184 | |

**FCFLOC2 Datum Shift**

| Segment | Shift X | Shift Y | Shift Z | Rotation X | Rotation Y | Rotation Z |
|---|---|---|---|---|---|---|
| Segment 1 | 0.000 | 0.000 | 0.000 | 0.000 | 0.227 | 0.000 |

**FCFLOC2 Summary  FIT TO DATUMS=ON,  DEV PERPEN CENTERLINE=ON**

| Feature | AX | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| Set | PR | 0.000 | 0.010 | 0.010 |
|  | PA | 308.996 | 313.444 | 4.448 |
| FLANGE_LEFT_CIR1 | PR | 75.800 | 75.801 | 0.001 |
|  | PA | 90.000 | 89.989 | -0.011 |
| FLANGE_LEFT_CIR2 | PR | 75.800 | 75.779 | -0.021 |
|  | PA | 110.000 | 109.989 | -0.011 |
| FLANGE_LEFT_CIR3 | PR | 75.800 | 75.785 | -0.015 |
|  | PA | 130.000 | 130.004 | 0.004 |
| FLANGE_LEFT_CIR4 | PR | 75.800 | 75.789 | -0.011 |
|  | PA | 150.000 | 150.009 | 0.009 |
| FLANGE_LEFT_CIR5 | PR | 75.800 | 75.802 | 0.002 |
|  | PA | 170.000 | 170.016 | 0.016 |

| | | | | |
|---|---|---|---|---|
| FLANGE_LEFT_CIR6 | PR | 75.800 | 75.802 | 0.002 |
| | PA | 190.000 | 190.006 | 0.006 |
| FLANGE_LEFT_CIR7 | PR | 75.800 | 75.799 | -0.001 |
| | PA | 210.000 | 210.012 | 0.012 |
| FLANGE_LEFT_CIR8 | PR | 75.800 | 75.791 | -0.009 |
| | PA | 230.000 | 229.999 | -0.001 |
| FLANGE_LEFT_CIR9 | PR | 75.800 | 75.790 | -0.010 |
| | PA | 250.000 | 250.008 | 0.008 |
| FLANGE_LEFT_CIR10 | PR | 75.800 | 75.819 | 0.019 |
| | PA | 270.000 | 269.997 | -0.003 |
| FLANGE_LEFT_CIR11 | PR | 75.800 | 75.834 | 0.034 |
| | PA | 290.000 | 290.000 | 0.000 |
| FLANGE_LEFT_CIR12 | PR | 75.800 | 75.814 | 0.014 |
| | PA | 310.000 | 309.998 | -0.002 |
| FLANGE_LEFT_CIR13 | PR | 75.800 | 75.801 | 0.001 |
| | PA | 330.000 | 329.993 | -0.007 |
| FLANGE_LEFT_CIR14 | PR | 75.800 | 75.795 | -0.005 |
| | PA | 350.000 | 349.996 | -0.004 |
| FLANGE_LEFT_CIR15 | PR | 75.800 | 75.796 | -0.004 |
| | PA | 10.000 | 9.998 | -0.002 |
| FLANGE_LEFT_CIR16 | PR | 75.800 | 75.818 | 0.018 |
| | PA | 30.000 | 29.995 | -0.005 |
| FLANGE_LEFT_CIR17 | PR | 75.800 | 75.808 | 0.008 |
| | PA | 50.000 | 49.993 | -0.007 |
| FLANGE_LEFT_CIR18 | PR | 75.800 | 75.822 | 0.022 |
| | PA | 70.000 | 69.983 | -0.017 |

| FCFPROF1 | MM | ⌒ .3 | FORMONLY VECTOR_LST_SQR ABOUT XPLUS |
|----------|-----|------|--------------------------------------|

| Feature | MEAS | MAX | MIN | |
|---------|------|------|-------|---|
| Set | 1.427 | 0.738 | -0.689 | |
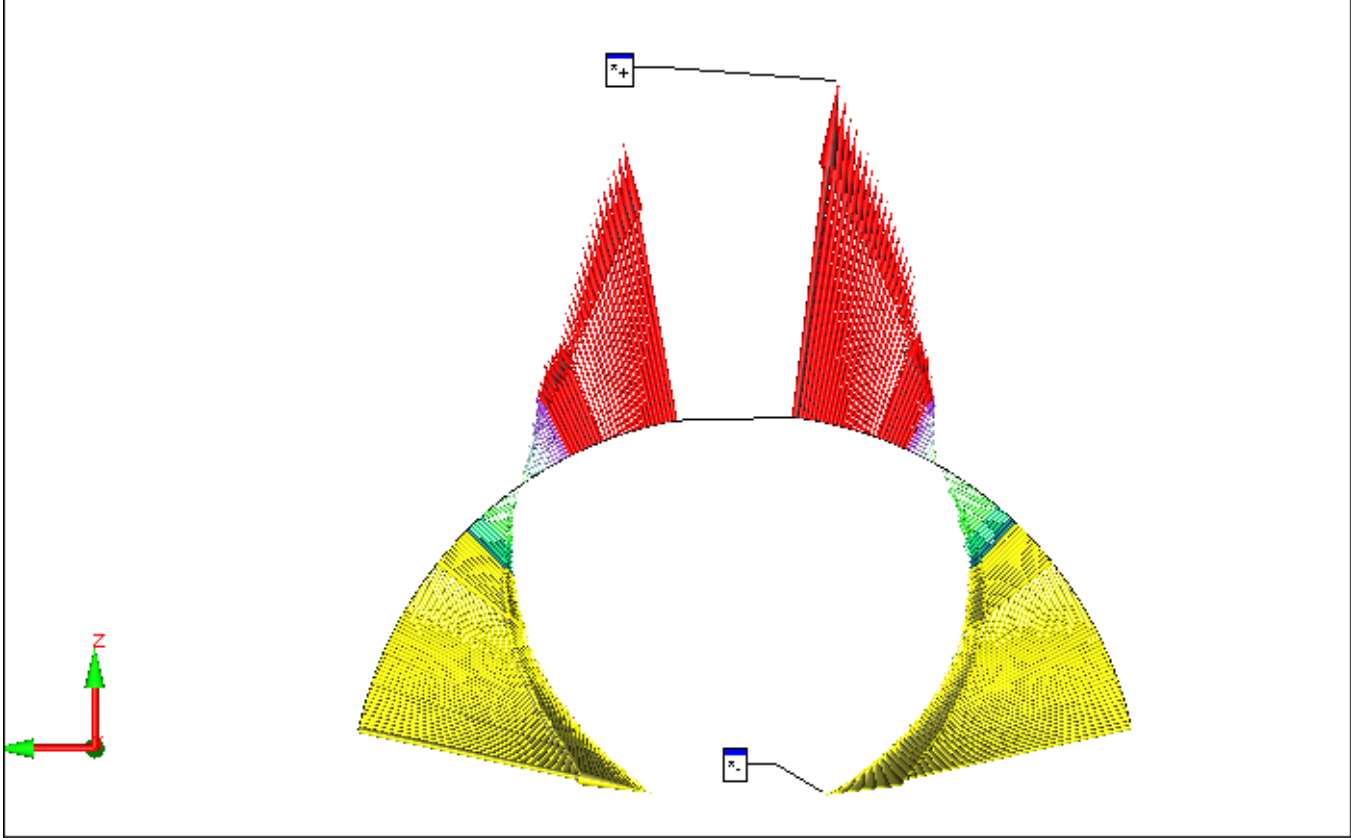


PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK- X100

| FCFPROF2 | MM | ⌒ .3 | FORMONLY VECTOR_LST_SQR ABOUT XPLUS |
|----------|-----|------|-------------------------------------|

| Feature | MEAS | MAX | MIN | |
|---------|------|-----|-----|---|
| Set | 1.383 | 0.685 | -0.697 | |
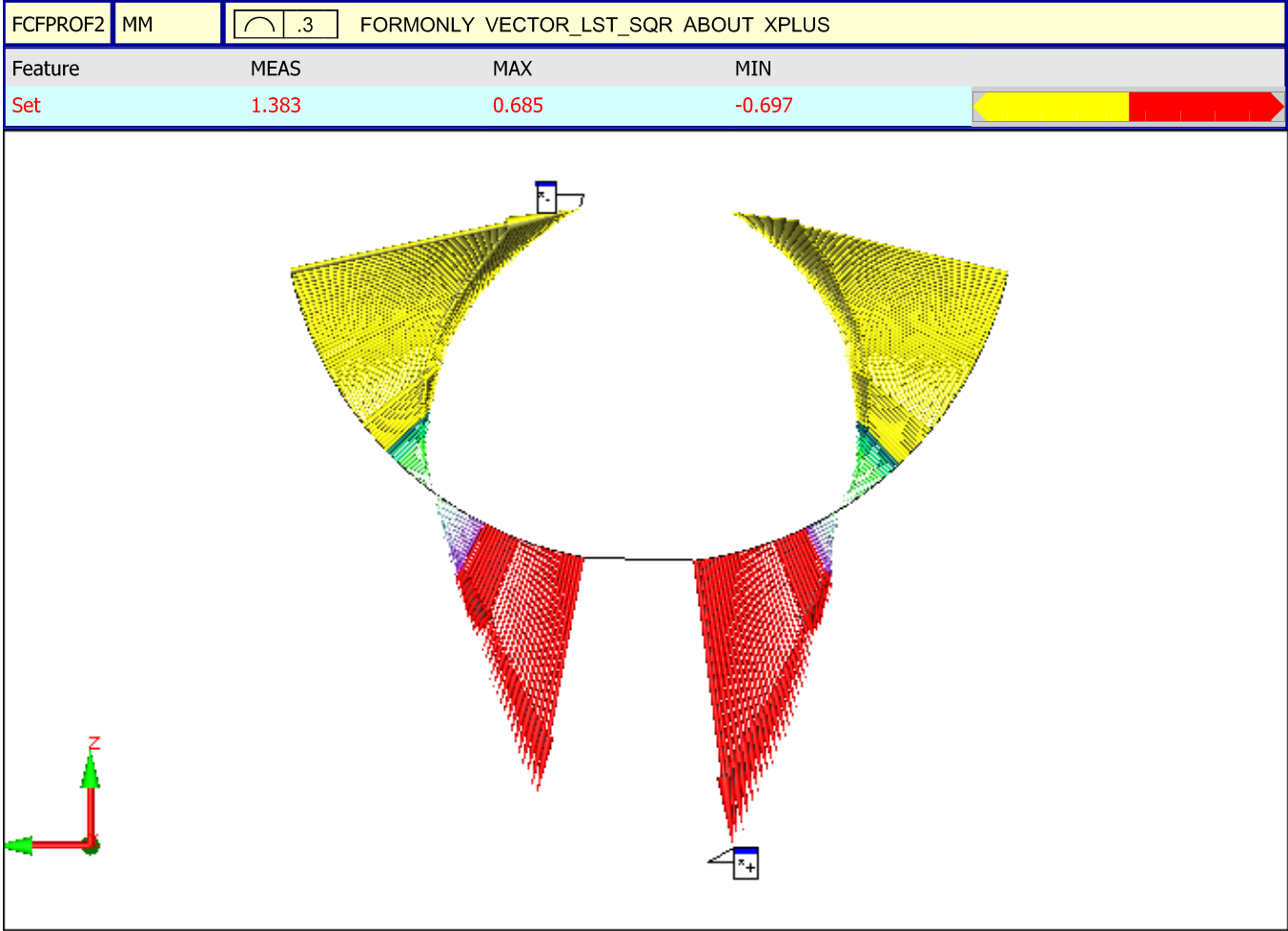


PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK- X100

| FCFPROF3 | MM | ⌒ .3 | FORMONLY VECTOR_LST_SQR ABOUT XPLUS |
|----------|-----|------|-------------------------------------|
| Feature | MEAS | MAX | MIN |
| Set | 1.090 | 0.313 | -0.777 |
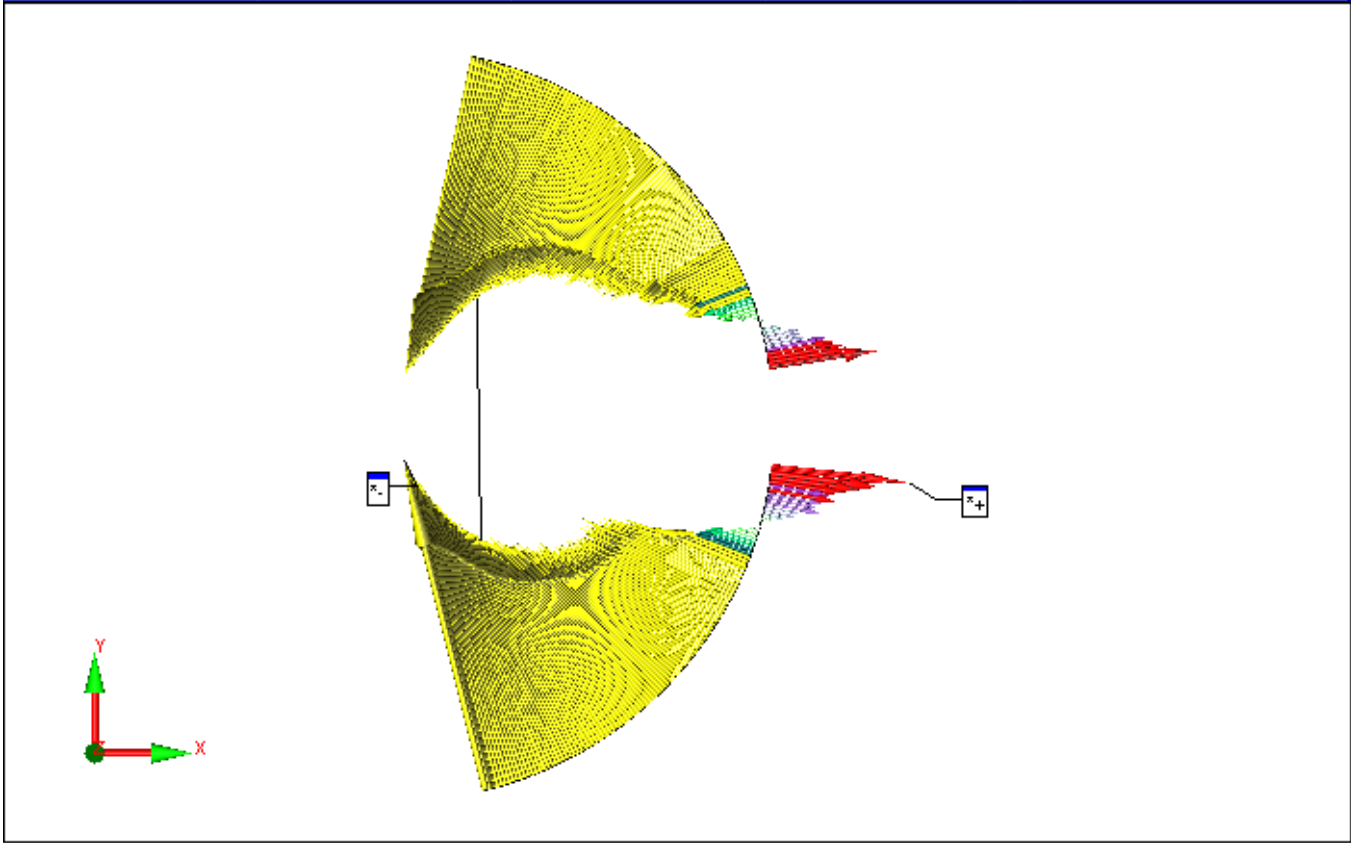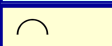


PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK- X100

| FCFPROF4 | MM | ⌒ .3 | FORMONLY VECTOR_LST_SQR ABOUT XPLUS |
| --- | --- | --- | --- |
| Feature | MEAS | MAX | MIN |
| Set | 0.845 | 0.168 | -0.677 |
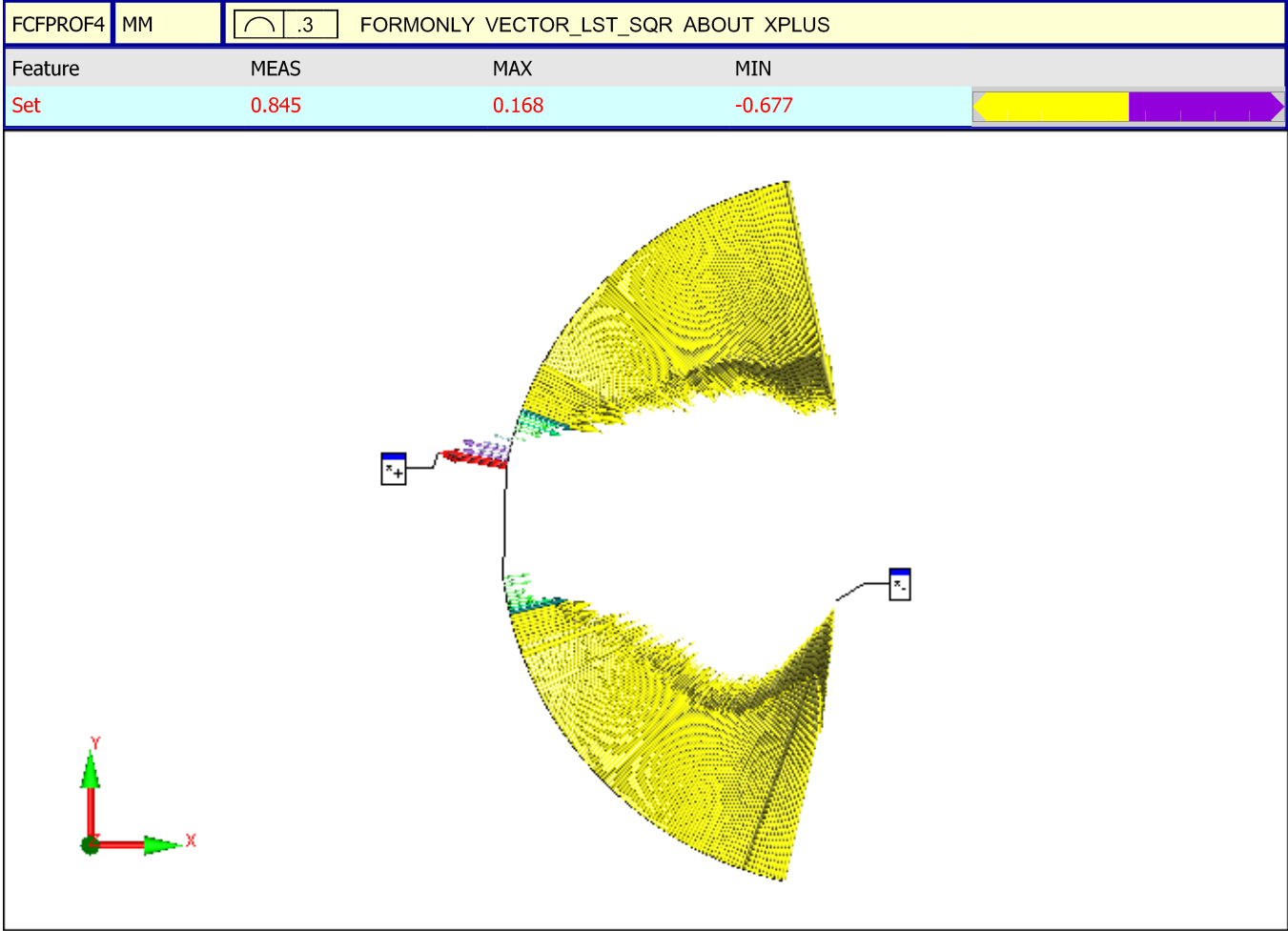
PROFILE OF RIGHT AND LEFT HALF CELLS 9 'O' CLOCK- X100
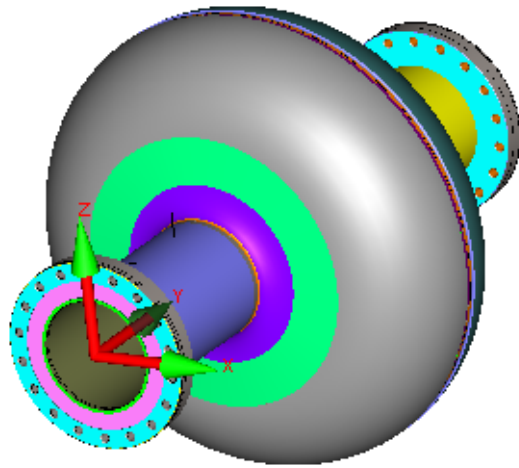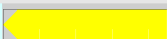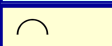
| ① | MM | FLANGE_RIGHT SURFACE FINISH | | | | |
|---|---|---|---|---|---|---|
| AX | | NOMINAL | MEAS | DEV | OUTTOL | |
| M | | 0.400 | 0.300 | -0.100 | 0.000 | |

| ① | MM | FLANGE_LEFT SURFACE FINISH | | | | |
|---|---|---|---|---|---|---|
| AX | | NOMINAL | MEAS | DEV | OUTTOL | |
| M | | 0.400 | 0.440 | 0.040 | 0.030 | |

| ⌢ | MM | PROF10 - ZPLUS_RIGHT_SCN1  FORMANDLOCATION | | | |
|---|---|---|---|---|---|
| AX | | MEAS | MAX | MIN | |
| M | | -0.882 | -0.105 | -0.882 | |

| ⌢ | MM | PROF11 - ZPLUS_LEFT_SCN1  FORMANDLOCATION | | | |
|---|---|---|---|---|---|
| AX | | MEAS | MAX | MIN | |
| M | | -0.867 | -0.217 | -0.867 | |

| ⌢ | MM | PROF14 - ZMINUS_RIGHT_SCN1  FORMANDLOCATION | | | |
|---|---|---|---|---|---|
| AX | | MEAS | MAX | MIN | |
| M | | -0.875 | -0.159 | -0.875 | |

| ⌢ | MM | PROF15 - ZMINUS_LEFT_SCN1  FORMANDLOCATION | | | |
|---|---|---|---|---|---|
| AX | | MEAS | MAX | MIN | |
| M | | -0.900 | -0.251 | -0.900 | |
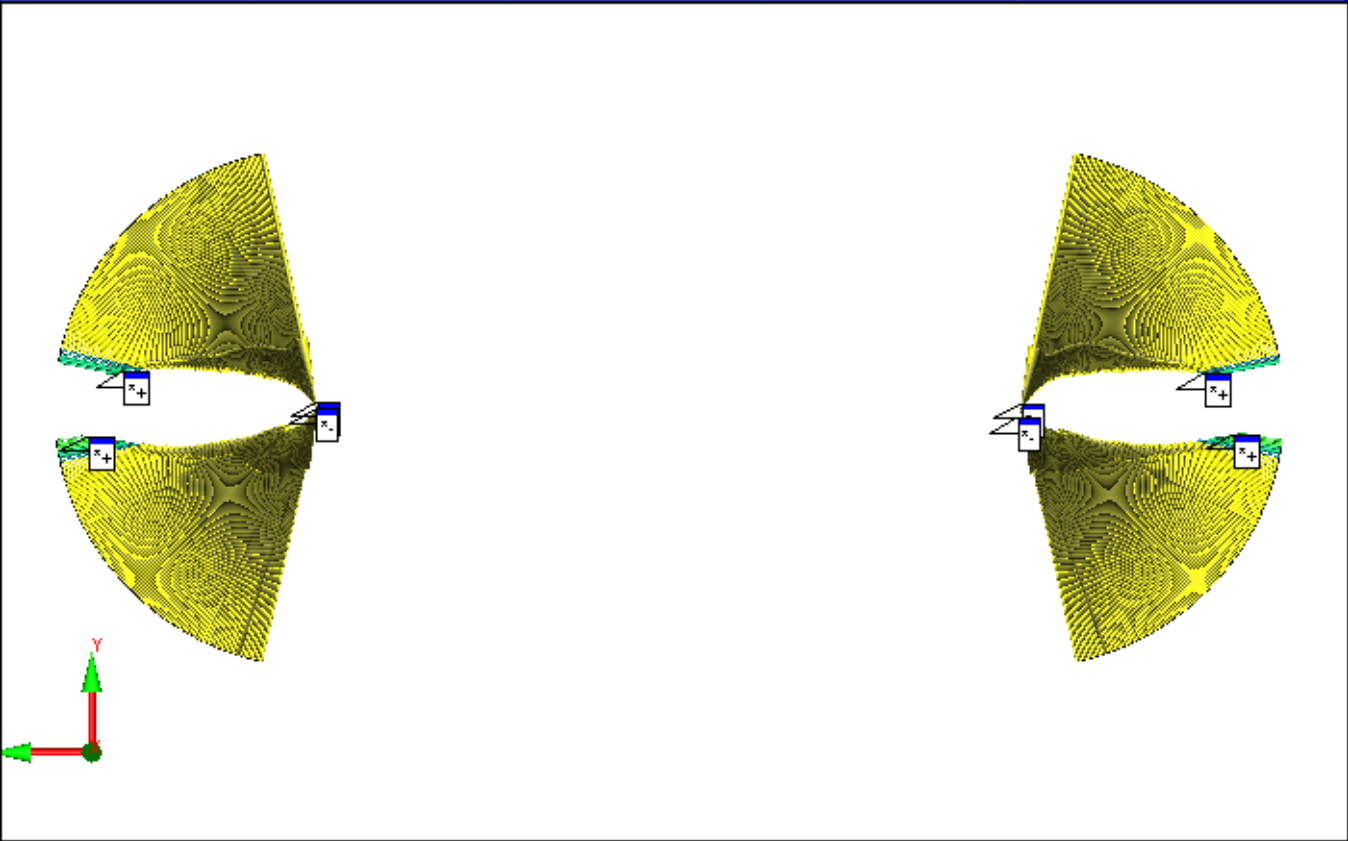


BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 12'O' and 6'0'CLOCK -X100

| PROF12 - XPLUS_LEFT_SCN1  FORMANDLOCATION | | | |
| --- | --- | --- | --- |
| AX | MEAS | MAX | MIN |
| M | -0.920 | -0.145 | -0.920 |

| PROF13 - XPLUS_RIGHT_SCN1  FORMANDLOCATION | | | |
| --- | --- | --- | --- |
| AX | MEAS | MAX | MIN |
| M | -0.933 | -0.071 | -0.933 |

| PROF16 - XMINUS_RIGHT_SCN1  FORMANDLOCATION | | | |
| --- | --- | --- | --- |
| AX | MEAS | MAX | MIN |
| M | -0.809 | -0.352 | -0.809 |

| PROF17 - XMINUS_LEFT_SCN1  FORMANDLOCATION | | | |
| --- | --- | --- | --- |
| AX | MEAS | MAX | MIN |
| M | -0.849 | -0.322 | -0.849 |



BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 9'O' and 3'0'CLOCK- X100